

# Work Order ID 67569

Monday, March 28, 2011 11:08:37 AM



Page 1

*Ship 1 week April*

Item ID: D4038-4

Accept



Setup Start



Revision ID:

Item Name: Angle, Aft, RH

Stop



Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *UMF*

Date: *11-03-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4038    | D            |

100

0.00



Bandsaw

Memo

0.00

*cut 11/03/29*

*3*

Jeaspa Bandsaw

Cut Blank 7.625" long

110

0.00



HAAS 1

Memo

0.00

*cut 11/03/30*

*3*

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: *11/03/29*

Folio Rev: *11/03/29*

Deburr

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 67569**

Monday, March 28, 2011 11:08:37 AM

Page 2

Item ID: D4038-4

Accept

Revision ID:

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Start Date: 3/28/2011 Start Qty: 3.00

Required Date: 4/5/2011 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

Quality Control

0.00

CML 11/03/30

3

φ

130

QC8- Inspect parts - second check

0.00



QC

Memo

Quality Control

0.00

B.A 11/03/31

3

φ

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

Hand Finishing

0:00

3

BR 11-3-31

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
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|      |      |                    |  |    |      |     |                                     |                          |  |

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|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries

[illegible]

Page 3

[illegible]

**Abstract**



**Abstract**



**Reference:**

**00000000000000000000**

[REDACTED]

**Insp.  
Stamp**

815

11/04/04

3

[illegible]

QC

## Memo

0.00

## Quality Control

0.00

SB

11604/04

③

[illegible]

### Packaging

## Memo

0.00

## Packaging

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

11/4/48

Plenary (3)

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

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|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, March 28, 2011 11:08:34 AM

Page 1

Work Order ID: 67569



Parent Item: D4038-4



Parent Item Name: Angle, Aft, RH



Start Date: 3/28/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit   | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M6061T6A4.000W.250<br> |                        | Purchased     | No          |                     |                  | 100             | f                  | 0.0000         | 0.7   | 2.210526     |               |                |        |
| 6061T6 ANGLE 4.00 x 4.00 x .250  |                        |               |             |                     |                  |                 |                    |                |  |              |               |                |        |

M114507 2.21" SW 11/03/29

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

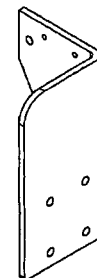
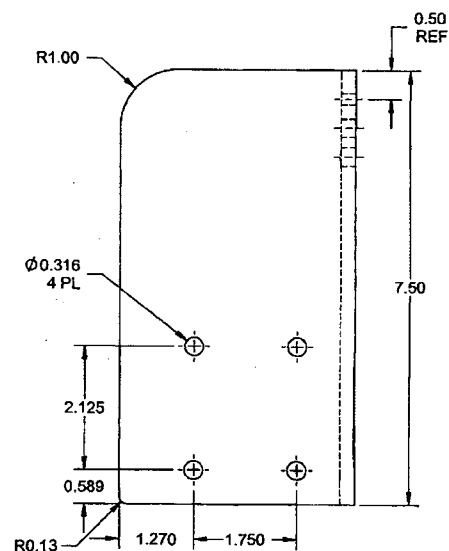
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries





# 67509

RELEASED  
2011-03-17

NOTES:

- 1) MATERIAL: 6061-T8/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RIDGE TOOL OF 0.015
- 7) WEIGHT: 1.19 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

|            |          |  |   |
|------------|----------|--|---|
| DESIGN     |          |  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br><br>DRAWING NO. <b>D4038</b><br><br>TITLE <b>BRACKET</b><br><br>COPYRIGHT © 2009 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD. |
| DRAWN      |          |  |   |
| CHECKED    |          |  |   |
| MFG. APPR. |          |  |   |
| APPROVED   |          |  |   |
| DE APPR.   |          |  |   |
| DATE       | 11.03.03 |  | REV. 0<br>SHEET 6 OF 6<br>SCALE<br>NTS  |

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
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|      |      |                    |  |    |      |     |                                     |                          |  |

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|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
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|      |      |                    |  |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries